

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029365**Date Inspected:** 02-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** Crest Hill, IL

CWI Name:	Robert Zimny		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** SAS Bridge Cab-Frame**Summary of Items Observed:**

Quality Assurance Inspector (QAI) James Kent Smith was at the USA Hoist shop in Crest Hill, Illinois between the times noted above in order to monitor Quality Control functions and the in process work being performed by USA Hoist personnel. The following items were observed:

Matt Wasigi, identification letter "A":

Qualified Welder "A" was observed during various intervals during the day welding the gusset plates (item #2) to the mast post(s) (item #1) as shown on approved drawing 914202-01-LH. He was utilizing Welding Procedure Specification (WPS) FCAW3210 with the 1.1mm E71T-1C Familiarc DW-50 wire electrode in the 2G position. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 38 CFH. The welding parameters were measured by this QAI using a Fluke clamp on meter, and were found to be 26 volts and 190 amperes which are in compliance with the WPS noted above. Following the completion of each weld made by "A", this QAI observed him to be checking the finished weld sizes using a weld file gage to ensure the 1/4" file weld size required by the approved drawings was being maintained. All completed welds were visually checked by this QAI and random weld size checks were also performed.

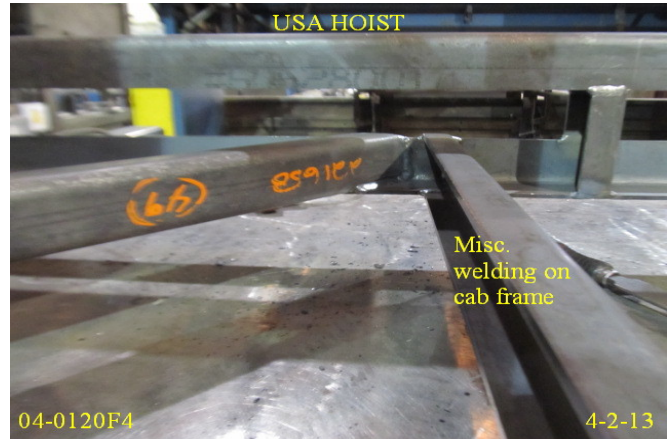
Manolo Luna, identification letter "B":

Qualified welder, "B" was observed during various intervals during the day to be performing miscellaneous welds on the cab-frame weldment as per approved drawing 916000. He was welding some areas that were left un-welded due to the position of the cab frame during the fabrication process; these welds were not finished due to the

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position of the weld joint at the time. US Hoist personnel wanted to wait to perform these welds due the weld areas being out of position, IE: not flat, so to ensure better weld application these welds were observed being done when cab frame is turned so that these welds can be performed in a more comfortable position or flat and with more ease of access to the areas in need of welding. Following the welding operation(s), "B" was observed grinding any areas that were in need of a flat surface and to remove any weld spatter that may have occurred. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications. Unless otherwise noted, work observed on this date appeared to generally comply with special provisions and applicable contract documents.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and USA Hoist Management and Quality Control personnel.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916)764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Smith, James

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer